

Date: Monday, 09/03/2009 1:42:30 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : END PLATE
<b>Job Number</b> : 46334	
<b>Estimate Number</b> : 10547	
<b>P.O. Number</b> :	<b>Part Number</b> : D30671
<b>This Issue</b> : 09/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3067 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44330	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 26/03/2009 <b>Qty:</b> 160 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.03.09</u>	
<b>Comment</b> : Est:03.01.21 Remove step 6 (Deburr) KJ	
Est Rev:B Now on Water jet 06-06-16 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M5052H32S063	5052-H32 .063 Sheet
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**Comment:** Qty.: 0.0656 sf(s)/Unit Total : 10.5000 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 (QQ-A-250/8)

M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)

Batch:

107276HB 9-3-13

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3067

Dwg Rev: AProg Rev: AHB 9-3-13209

2-Deburr if necessary

HB 9-3-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 9-3-13**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK090313 209 counted

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Bend as per Dwg D3067

SB 09/03/16 209

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 46334

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO NEXT STEP

02/03/17 (209)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *QAT*

9/3/18

(209) SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/18

Job Completion



MF 09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

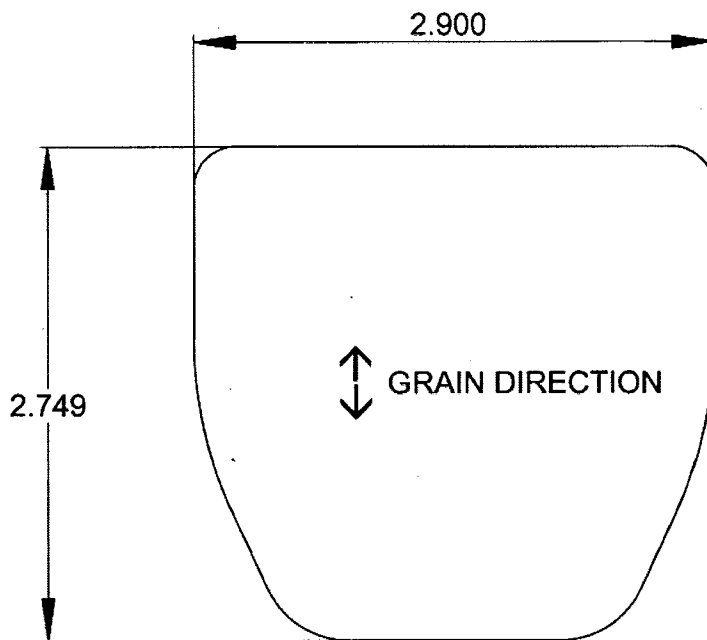
**NOTE:** Date & initial all entries



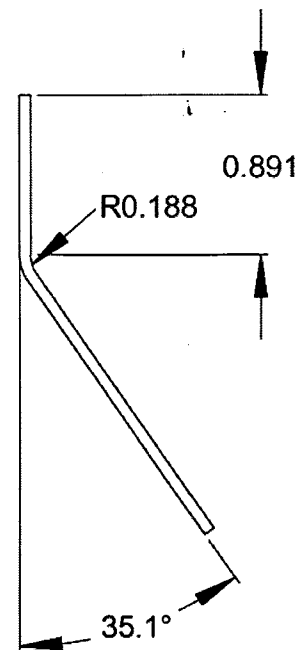


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>UP</i>	DRAWING NO. <b>D3067</b>	REV. A SHEET 1 OF 1
DATE <b>02.09.11</b>		TITLE <b>END PLATE</b>	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063) OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063) ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO  
ENGINEERING

CONTROLLED COPY

TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 46334

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